Work Order ID 166083

Monday, September 11, 2017 9:06:50 AM

166083

Ship Oct 11

Item ID: K591-113
Revision ID:
Item Name: Short Step Installation

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 9/11/2017 **Start Qty:** 4.00 *4*
Required Date: 9/20/2017 **Req'd Qty:** 4.00 *4*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** DAS 21 9-89 **Date:** SEP 1 1 2017 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Draw Nbr	Revision Nbr
DSI9525	A

SEP 1 1 2017 SL

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
104	Pick Kit	0.00							
104 Packaging					Y	DAS 27 9-89			
Packaging	**Memo**	0.00							
105	QC4- 100% Inspect kits for completeness	0.00							
105 QC						Y DAS 6 9-89		SEP 12 2017	DAS 28 9-89
Quality Control	**Memo**	0.12							
110	Identify as per dwg & Stock Location: Fg019	0.00							
110 Packaging					Y	DAS 27 9-89			
Packaging	**Memo** ***CHG005***	0.04							

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No.	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐

Date :	Step #:	QTY Effective :	**MRB (QSI042) Approval**
Description Work Order Deviation		**Disposition**	
			Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

Root Cause				**FAULT CATEGORY**			
Environment	☐	☐	No Re-verfication	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
Design	☐	☐	Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
Doc/Data	☐	☐	Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
Equip/Tooling	☐	☐	Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
Handling/Pre	☐	☐	Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Material	☐	☐	Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
Internal Transport	☐	☐	Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
Tribal Knowledge	☐	☐	Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
LOA	☐	☐	Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
Substation	☐	☐	Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
Past Expiry Date	☐	☐	Manufacturing Process				
Misidentified	☐	☐	Past Due	☐ OTHER :			

Work Order ID 166083

Monday, September 11, 2017 9:06:50 AM

166083

Item ID: K591-113

Revision ID:

Item Name: Short Step Installation

Start Date: 9/11/2017 **Start Qty:** 4.00 *4*

Required Date: 9/20/2017 **Req'd Qty:** 4.00 *4*

Reference:

Accept *N9000040100*

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		
120 QC Quality Control	Memo	0.40							SEP 14 2017

DAS 21 9-89

SEP 14 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No.

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Date :

Step #:

QTY Effective :

MRB (QSI042) Approval

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor Approval Verification

QC / QA Coordinator Approval

Root Cause

Environment	☐	☐	No Re-verfication
Design	☐	☐	Operator
Doc/Data	☐	☐	Offset/Setup
Equip/Tooling	☐	☐	Supplier
Handling/Pre	☐	☐	Training
Material	☐	☐	Use for Testing
Internal Transport	☐	☐	Poor Information
Tribal Knowledge	☐	☐	Rushing
LOA	☐	☐	Product Improvement
Substation	☐	☐	Process Improvement
Past Expiry Date	☐	☐	Manufacturing Process
Misidentified	☐	☐	Past Due

FAULT CATEGORY

☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

☐ OTHER :

Picklist Print

Monday, September 11, 2017 9:06:56 AM

Work Order ID: 166083

166083

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Installation

Start Date: 9/11/2017 **Required Date:** 9/20/2017

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP : C04.11.09ReformatKJ/JLM IPP Rev:D as per revG DD 10.04.20 verified by:EC IPP Rev:E as per ECN10-586 10.06.18 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2171		Manufactured	No			104	Each	10.0000	2	8			
D2171									**				
Clamp													
				Location			**Loc Qty**		**Loc Code**				
				ST542			10						
					162930		10						
D2274		Manufactured	No			104	Each	232.0000	4	16			
D2274									**				
Radius Block													
				Location			**Loc Qty**		**Loc Code**				
				FG			4						
					86855		4						
				Return2017			16						
					152449		16						
				ST006			52						
					151763		12						
					155086		40						
				ST012a			160						
					157272		160						
D2182B		Manufactured	No			104	f	50.5985	0.5833	2.3332			
D2182B									**				
Rubber Cushion - Black ($Per Foot)													
				Location			**Loc Qty**		**Loc Code**				
				ST411			50.5985						
					135093		0.5985						
					160459		50						

(D2182B035) CUT 2 AT 3.50"

DAS 27 9-89 DAS 6 9-89 SEP 12 2017 DAS 28 9-89

DAS 27 9-89 DAS 6 9-89 SEP 12 2017 DAS 28 9-89

DAS 27 9-89 DAS 6 9-89 SEP 12 2017 DAS 28 9-89

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No.	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval

Description Work Order Deviation	Disposition	
		Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause

Environment	☐	☐	No Re-verfication
Design	☐	☐	Operator
Doc/Data	☐	☐	Offset/Setup
Equip/Tooling	☐	☐	Supplier
Handling/Pre	☐	☐	Training
Material	☐	☐	Use for Testing
Internal Transport	☐	☐	Poor Information
Tribal Knowledge	☐	☐	Rushing
LOA	☐	☐	Product Improvement
Substation	☐	☐	Process Improvement
Past Expiry Date	☐	☐	Manufacturing Process
Misidentified	☐	☐	Past Due

FAULT CATEGORY

☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Crimp/Kink/Ripple, Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

☐ OTHER :

Picklist Print

Monday, September 11, 2017 9:06:56 AM

Work Order ID: 166083

Parent Item: K591-113

Parent Item Name: Short Step Installation

166083
K591-113

Start Date: 9/11/2017 **Required Date:** 9/20/2017

Start Qty: 4.00 **Required Qty:** 4.00

D2362-3 Manufactured No 104 Each 15.0000 1 4

D2362-3

Step Support Bracket

DAS 27 9-89

Location	Loc Qty	Loc Code
ST537	15	
163781	3	
165304	12	

SEP 1 2 2017 DAS 6 9-89 DAS 28 9-89

D3595-200-300 Manufactured No 104 Each 29.0000 1 4

D3595-200-300

Rubber Cushion 2.00" wide x 3.00" Long

DAS 27 9-89

Location	Loc Qty	Loc Code
FG	1	
84209	1	
ST041	28	
162261	28	

SEP 1 2 2017 DAS 6 9-89 DAS 28 9-89

AN3-37A Purchased No 104 Each 115.0000 2 8

AN3-37A

Bolt

DAS 27 9-89

Location	Loc Qty	Loc Code
FG	10	
119086	10	
over003	30	
m136983	30	
ST347	75	
m137587	25	
m138441	50	

SEP 1 2 2017 DAS 6 9-89 DAS 28 9-89

Picklist Print

Monday, September 11, 2017 9:06:56 AM

Work Order ID: 166083

166083

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Installation

Start Date: 9/11/2017 **Required Date:** 9/20/2017

Start Qty: 4.00 **Required Qty:** 4.00

AN4-21A Purchased No 104 Each 95.0000 4 16

AN4-21A

Bolt

**

DAS 28 9-89

SEP 1 2 2017

DAS 6 9-89

Location	Loc Qty	Loc Code
over003	95	
m136665	20	
~~m138441~~	50	
mm138045	25	

DAS 27 9-89

AN4-22A Purchased No 104 Each 40.0000 1 4

AN4-22A

Bolt

**

SEP 1 2 2017

DAS 28 9-89

DAS 6 9-89

Location	Loc Qty	Loc Code
over003	20	
m137951	20	
ST342	17	
m138045	17	
ST344	3	
116419	3	

DAS 27 9-89

NAS1149D0363J Purchased No 104 Each 1,339.000 4 16

NAS1149D0363J

Washer

**

DAS 28 9-89

DAS 6 9-89

SEP 1 2 2017

Location	Loc Qty	Loc Code
GA	408	
m137963	408	
ST263	931	
126319	16	
m138336	915	

DAS 27 9-89

Picklist Print

Monday, September 11, 2017 9:06:57 AM

Work Order ID: 166083

166083

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Installation

Start Date: 9/11/2017 **Required Date:** 9/20/2017

Start Qty: 4.00 **Required Qty:** 4.00

NAS1149D0463J Purchased No 104 Each 2,122.000 6 24

NAS1149D0463J

Washer

**

DAS 6 9-89 DAS 28 9-89

SEP 12 2017

Location	Loc Qty	Loc Code
GA	451	
M135056	40	
M137699	411	
Return2017	16	
M136665	16	
ST263	1655	
M137988	600	
M138084	27	
M138230	1028	

DAS 27 9-89

24

MS21042L3 Purchased No 104 Each 1,742.000 2 8

MS21042L3

Nut

**

DAS 6 9-89 DAS 28 9-89

SEP 12 2017

Location	Loc Qty	Loc Code
FP001	72	
m135945	72	
GA	332	
m134360	102	
M136665	230	
OVER007	500	
m138408	500	
ST303	838	
m138230	500	
m138326	338	

DAS 27 9-89

8

Picklist Print

Monday, September 11, 2017 9:06:57 AM

Work Order ID: 166083

166083

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Installation

Start Date: 9/11/2017 **Required Date:** 9/20/2017

Start Qty: 4.00 **Required Qty:** 4.00

MS21042L4	Purchased	No	104	Each	2,161.000	5	20	

MS21042L4

Nut

**

DAS 28 9-89

DAS 6 9-89

SEP 17 2017

DAS 27 9-89

Location	Loc Qty	Loc Code	
FP001	10		
m133363	10		
OVER007	1000		
m138170	500		
m138230	500		
ST303	1151		
m138084	151		20
m138326	1000		

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 *Heli-Access-Step*™ (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					**D350-591-111A**	**Heli-Access-Step™, Long Step – High Skid**
	X				**D350-591-113**	**Heli-Access-Step™, Short Step – High Skid**
		X			**D350-591-115**	**Heli-Access-Step™, Short Step – Low Skid**
			X		**D350-591-117A**	**Heli-Access-Step™, Pre-Flight Step**
				X	**D350-591-119**	**Heli-Access-Step™, Long Step – Low Skid**
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION **(NEW)**
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT **(REPLACED, WAS AN4-16A)**
8	4			4	AN4-21A	BOLT **(REPLACED, WAS AN4-20A)**
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166083
120911

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: _____
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE.	JPH	10.06.08

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9525 SHEET 1 OF 4
APPROVED		TITLE SCALE
DE APPR.		STEP CUSHION CHANGE NTS
DATE	10.06.08	

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THE DSI-9525-XXX KITS THAT ARE AVAILABLE FROM DART TO UPGRADE THE D350-591-111A/-113/-115 KITS @ CHG 004 (OR EARLIER), THE D350-591-117A KIT @ CHG 002 (OR EARLIER) AND THE D350-591-119 KIT @ CHG 003 (OR EARLIER) ARE AS FOLLOWS:

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				**DSI-9525-011**	**STEP CUSHION KIT (FOR D350-591-111A)**
	X			**DSI-9525-013**	**STEP CUSHION KIT (FOR D350-591-113/-119)**
		X		**DSI-9525-015**	**STEP CUSHION KIT (FOR D350-591-115)**
			X	**DSI-9525-017**	**STEP CUSHION KIT (FOR D350-591-117A)**
2	1	1	1	D3595-200-300	CUSHION
		4		AN4-20A	BOLT
8	4			AN4-21A	BOLT
			4	AN4-22A	BOLT
8	4	4	4	NAS1149D0463J	WASHER (OR AN960JD416)
8	4	4	4	MS21042L4	NUT

INSTRUCTIONS:

TO INSTALL THE D3595-200-300 CUSHION:

1. REMOVE THE STEP PER ICA-D350-591 SECTION 32.2
2. REMOVE THE D2856-400-720 ABRASION STRIP PER ICA-D350-591 SECTION 32.4
3. POSITION THE D3595-200-300 CUSHION AS INDICATED ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.
4. REINSTALL THE STEP PER ICA-D350-591 SECTION 32.1 AS APPLICABLE USING THE NEW HARDWARE PROVIDED AS SHOWN ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.

WEIGHT AND BALANCE:

THERE IS A NEGLIGIBLE WEIGHT INCREASE WITH THIS MODIFICATION.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: _____
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9525 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		STEP CUSHION CHANGE NTS
DATE	10.06.08	

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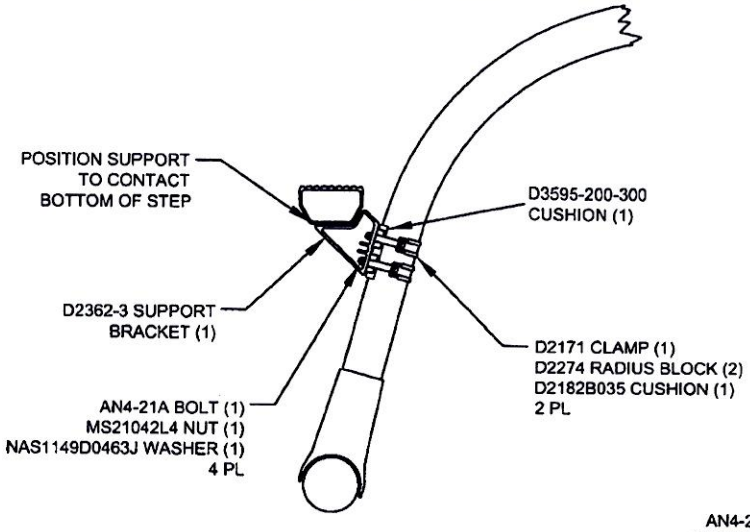
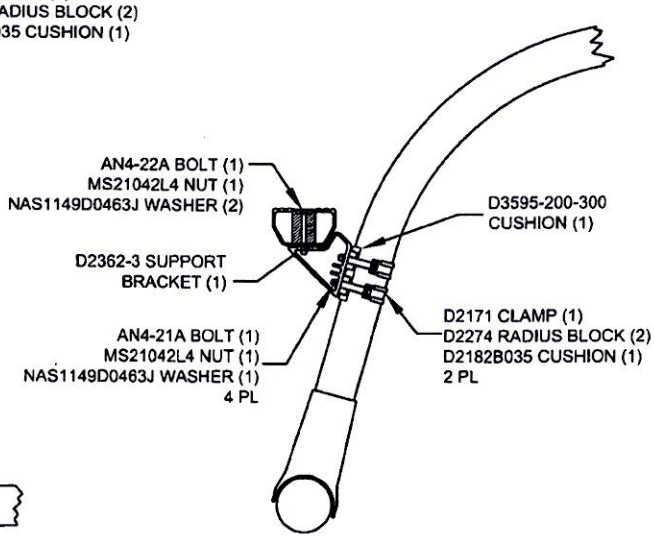
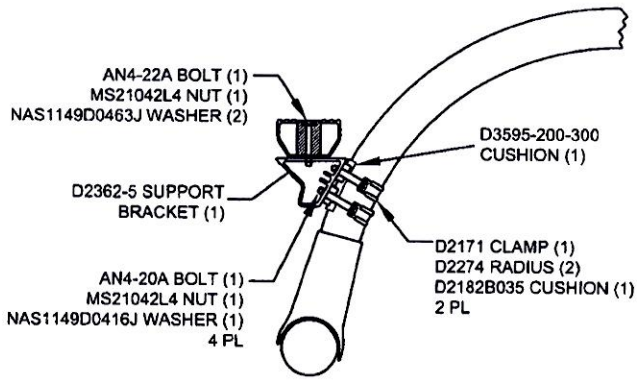


SECTION C-C: CENTER SUPPORT
(D350-591-111A ONLY)
(NOT TO SCALE)



SECTION D-D: AFT ATTACHMENT
(D350-591-111A/-113/-119 ONLY)
(NOT TO SCALE)



SECTION E-E: AFT ATTACHMENT
(D350-591-115 ONLY)
(NOT TO SCALE)

FIGURE 32-9: Crosstube Attachment
REF ICA-D350-591
FIGURE 9: Crosstube Attachment
REF D350-591

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: _____
D. SHEPHERD (DE # 02)
DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9525 SHEET 3 OF 4
APPROVED		TITLE SCALE
DE APPR.		STEP CUSHION CHANGE NTS
DATE	10.06.08	

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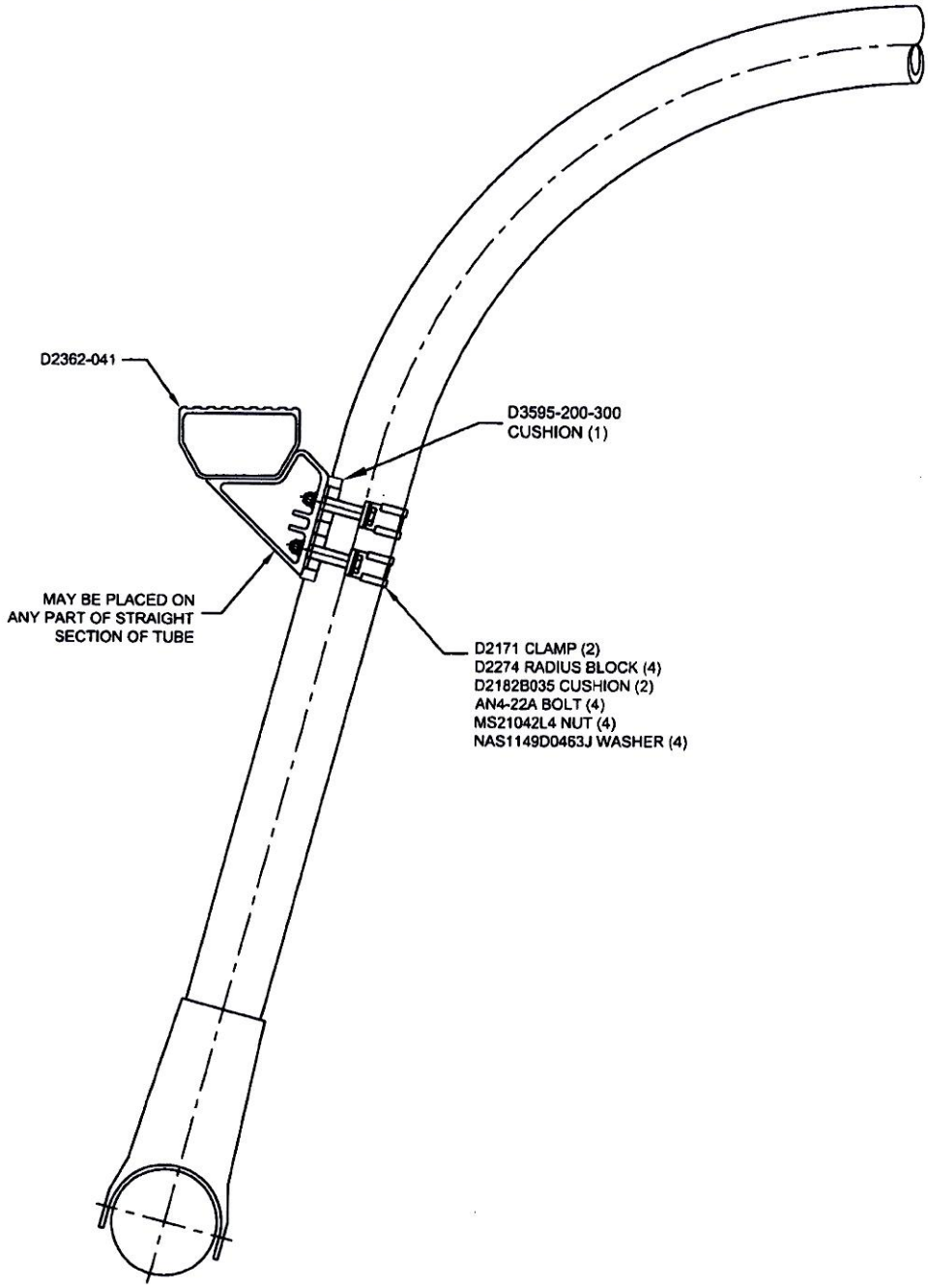

FIGURE 32-10: D350-591-117A ***Heli-Access-Step***™, Pre-Flight Step
REF ICA-D350-591

FIGURE 10: D350-591-117A ***Heli-Access-Step***™, Pre-Flight Step
REF D350-591

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: _____
D. SHEPHERD (DE # 02)
DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9525 SHEET 4 OF 4
APPROVED		TITLE SCALE
DE APPR.		STEP CUSHION CHANGE NTS
DATE	10.06.08	

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REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 *Heli-Access-Step*™ (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	**Heli-Access-Step™, Long Step – High Skid**
	X				D350-591-113	**Heli-Access-Step™, Short Step – High Skid**
		X			D350-591-115	**Heli-Access-Step™, Short Step – Low Skid**
			X		D350-591-117A	**Heli-Access-Step™, Pre-Flight Step**
				X	D350-591-119	**Heli-Access-Step™, Long Step – Low Skid**
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION **(NEW)**
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT **(REPLACED, WAS AN4-16A)**
8	4			4	AN4-21A	BOLT **(REPLACED, WAS AN4-20A)**
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

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REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE.	JPH	10.06.08

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DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9525 SHEET 1 OF 4
APPROVED		TITLE SCALE
DE APPR.		STEP CUSHION CHANGE NTS
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